[0142] Only water was used as a solvent in Composition U. The dried weight of the U1-U3 changed consistently in accordance with the change in coating thickness indicating that no air bubbles were present. However, these films contained 20% moisture upon exit from the oven, unlike the films of Composition T, which included part ethanol and dried completely

[0143] The amount of solids was increased and the amount of water was decreased in Compositions V1 and V2. The dried weight was greater than U1-U3 due to the increase in solids, however the films still contained 20% moisture upon exit from the oven, similar to Composition U.

[0144] The coating line speed was reduced for Composition V3, to prevent premature drying of the exposed top film surface. This film product dried to 6% moisture

[0145] While increasing the amount of solids improved the film weight, longer drying times were required. This was due to the surface of the film sealing preventing easy removal of the water. Therefore, for Compositions W1-W3, the temperature in the first 3m section of the dryer was decreased. This prevented the premature drying of the top surface of the films. Even at greater film thicknesses, the films were dried to 5% moisture even at faster coater line speeds.

TABLE 8

	Weight (g)			
Ingredient	X	Y	Z	AA
Lecithin	104.69			
Tonic		52.35		
Pectil			104.69	
Hydroxypropyl methylcellulose	320	320	320	150
Sweetener blend	60	60	60	9.4
Dimethicone	1.5	1.5	1.5	1.5
Propylene glycol	100	100	100	
Water	1440	1440	1440	790
Cream essence				9.4
Polyvinyl pyrrolidinone				4
Ethanol				40
Cocoa				55.2
Polyoxyl-40-stearate				7